

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 158997

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158997

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Item ID: D407-797-111

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 4/7/2017 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 4/21/2017 Req'd Qty: 3.00 ***3***

Customer:

Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D407-797-111 Location:FG034								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.30							
Quality Control									

3 DAS
28
9-89

APR 08 2017

DAS
21
9-89

APR 10 2017

DAS
21
9-89

APR 10 2017

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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158997

D407-797-111

Required Date: 4/21/2017

Required Qty: 3.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-011		Manufactured	No			110	Each	2.0000	1	3		APR 05 2017	
D4271-011									**	158831X1			DAS 6 28 9-89 9-89
Beam Assembly, Fwd													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST452				2					
				151055				1					
				153100				1					
D4271-013		Manufactured	No			110	Each	1.0000	1	3		APR 05 2017	
D4271-013									**	158821XL			DAS 6 28 9-89 9-89
Beam Assembly, Aft													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST453				1					
				153087				1					
D4292-1		Manufactured	No			110	Each	12.0000	2	6			
D4292-1									**			APR 05 2017	DAS 6 28 9-89 9-89
Fitting													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st533				12					
				151725				2					
				156350				6					
				156913				4					

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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Work Order ID: 158997

158997

Parent Item: D407-797-111

D407-797-111

Parent Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 4/7/2017

Required Date: 4/21/2017

Start Qty: 3.00

Required Qty: 3.00

D4294-1 Manufactured No

110 Each 10.0000 2 6

D4294-1

Fitting

DAS
27
9-89

Location

Loc Qty

Loc Code

st533

10

151724

4

156912

6

APR 05 2017

DAS
6
28
9-89

D4314-1 Manufactured No

110 Each 21.0000 4 12

D4314-1

Shim

DAS
27
9-89

Location

Loc Qty

Loc Code

ST091

21

151130

5

156485

4

156996

8

158245

4

APR 05 2017

DAS
6
28
9-89

D4314-3 Manufactured No

110 Each 21.0000 4 12

D4314-3

Shim

DAS
27
9-89

Location

Loc Qty

Loc Code

ST091

21

123115

7

154329

10

158248

4

APR 05 2017

DAS
6
28
9-89

AN6-17A Purchased No

110 Each 16.0000 2 6

AN6-17A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST334

16

m135671

6

m136838

10

APR 05 2017

DAS
6
28
9-89

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
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							Completed By 		
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

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Work Order ID: 158997

158997

Parent Item: D407-797-111

D407-797-111

Parent Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 4/7/2017

Required Date: 4/21/2017

Start Qty: 3.00

Required Qty: 3.00

AN6-20A Purchased No

110 Each

28.0000

2 6

AN6-20A

BOLT

**

APR 05 2017

Location

Loc Qty

Loc Code

over005

15

M136148

15

ST334

13

M134943

13

NAS1149D0663J Purchased No

110 Each

535.0000

8 24

NAS1149D0663J

Washer

**

APR 05 2017

Location

Loc Qty

Loc Code

ST260a

500

M136787

500

ST263

35

M136192

35

MS21042L6 Purchased No

110 Each

151.0000

4 12

MS21042L6

Nut

**

APR 05 2017

Location

Loc Qty

Loc Code

ST303

51

m136450

1

m137075

50

ST313

100

m136740

50

m136986

50

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Work Order ID: 158997

158997

Parent Item: D407-797-111

D407-797-111

Parent Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 4/7/2017

Required Date: 4/21/2017

Start Qty: 3.00

Required Qty: 3.00

MS27151-19

Purchased

No

110

Each

29.0000

4

12

MS27151-19

NUT

DAS
27
9-89

Location

Loc Qty

Loc Code

ST275

29

m132285

18

m132399

11

APR 05 2017

DAS
28
6
9-89

MS24694-10

MS24694-S10

Purchased

No

110

Each

0.0000

4

12

MS24694-10

SCREW

D4713-1

Manufactured

No

110

Each

37.0000

1

3

D4713-1

Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST121

37

146084

37

APR 05 2017

DAS
28
6
9-89

APR 05 2017

DAS
28
6
9-89

MS3367-5-0

Purchased

No

110

Each

81.0000

1

3

MS3367-5-0

Tie Wrap

DAS
27
9-89

Location

Loc Qty

Loc Code

ST272

81

123164

81

APR 05 2017

DAS
28
6
9-89

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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

5.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Qty -111	Part Number	Description
X					D407-797-011	QUICK RELEASE HELI-UTILITY-BASKET
	X				D407-797-012	QUICK RELEASE HELI-UTILITY-BASKET
		X			D407-797-013	QUICK RELEASE HELI-UTILITY-BASKET
			X		D407-797-014	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D407-797-111	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4294-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP

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[illegible]